

ASAP

Dart Aerospace Ltd.

Date: Thursday, 8/23/2007 11:52:24 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 34234						
Estimate Number	: 10673						
P.O. Number	: N/A			Part Number	: D2975		
This Issue	: 8/23/2007	S.O. No.	: N/A	Drawing Number	: D2975 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A			Drawing Revision	: A		
Previous Run	: 29538			Material	: N/A		
Written By	: <u>JL</u>			Due Date	: 9/3/2007		
Checked & Approved By	: <u>JL 07.08.23</u>			Qty:	10		
Comment	: Est: C 02.10.23 Re-format KJL			Um:	Each		
	Est Rev:D Now on Waterjet 06-11-21 JLM						

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s)

1010/1025/A21/6aA SHEET 063"

Batch: M103439 IB07-08-24

Batch: M10343 | BOK-08-04

Comment: FLOW WATER JET

1-Cut as per Dwg D2975

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

A standard linear barcode is positioned in the upper left corner of the page.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

Comment: NC BRAKE

Deburr if necessary

Form as per dwg D2975 using DT8261 & DT8326

SB 07/08/28
SB 07/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 34234		Part Number: D2975
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>EP 8/28/08 (18)</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using DT8210 as per Dwg D2975 & QSI 004 Qty Description Batch A/R 7560 Hardcoat Rod <u>M105465</u>		<i>8/07/09/13</i>
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>8/07/09/13 (19)</i>
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <i>ML 8/09/14</i>		<i>(19)</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>ML 07-09-14 (19)</i>
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>2/9/14 SP (19)</i>
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>10/09/17 (19)</i>
Job Completion		
<i>Cd 07/09/17</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34234
Description: Wearplate	Part Number:	D2975
Inspection Dwg: D2975	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

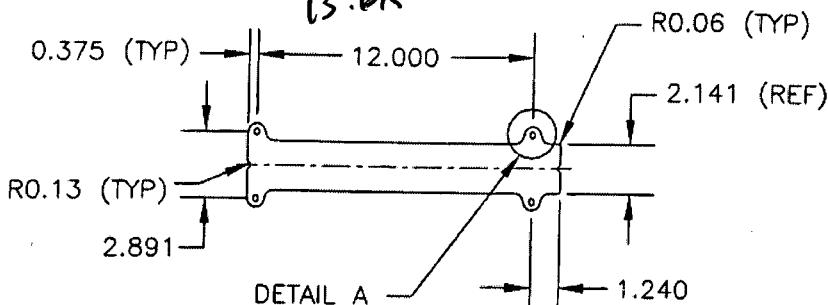
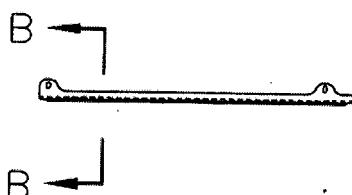
X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>Er</u>	Prototype Approval: N/A
Date: 07-08-24	Date: 07/08/27	Date: N/A

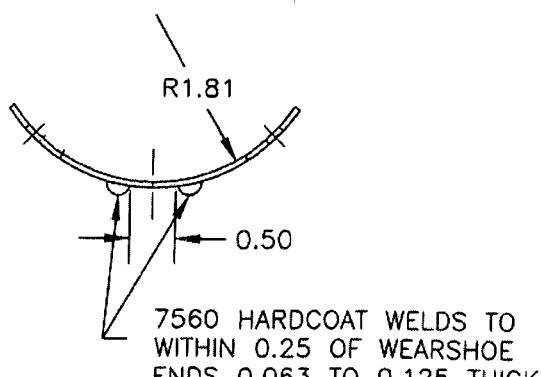
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	

DARTCOPY ISSUE
C

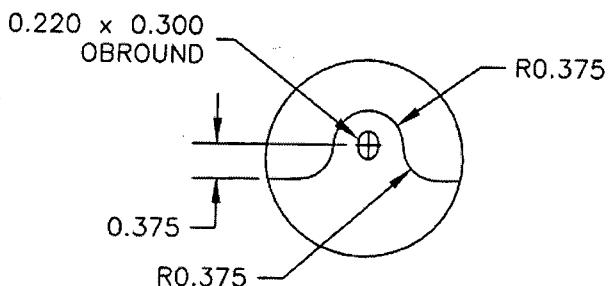
DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975
DATE 00.03.10		REV. A SHEET 1 OF 1
		TITLE WEARPLATE
A	00.03.10	SCALE 1:8 NEW ISSUE

FLAT PATTERN*13.6K*BENDING DETAILSECTION B-B

SCALE 2:5

DETAIL A

SCALE 2:5



BREAK ALL SHARP EDGES 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
 16 GAUGE (0.063 THICK)
 FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005-43
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

RELEASED
00.05.11 *[Signature]*

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 34234